

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.21**WELDING WITNESS REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WWR-000238**Date Inspected:** 04-Jun-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**Location:** Shanghai, China

Witness: **Procedure Qualification Record**
Welding **NDT**

Welder Qualification **Fracture Critical**
Mechanical Testing, describe: Fillet Macro-etch

Index Lot #: B72-038-07**Witness Lot #:** B60-037-07**Bridge No:** 34-0006**Component:** Bid: 52,55 Tower & Girder**Welder:** Zhu Hai Ping**ID #:** N/A**Joint Description:** Fillet

N/A

WPS ID #: PWPS-B-T-3114

N/A

Base Metal: A709M-HPS-485W

N/A

PQR ID #: HP200781-1

N/A

Thickness: 25 millimeters

N/A

Process: SMAW

N/A

Electrode Spec/Class: AWS A5.5/ E9018M MR

N/A

Positions: Overhead 4F

N/A

Backing Material: A709M-HPS-485W

N/A

CWI: Wei Huang

N/A

Average Amps:

N/A

AWS Code: AWS D1.5 2002

N/A

Average Volts:

N/A

Applicable Sec: Paragraph 5.13

N/A

Travel Speed:

N/A

Heat Input:

N/A

Preheat:

N/A

Summary of Items Observed:

The Caltrans Quality Assurance (QA) Inspector observed Macro-etch tests for the above Weld Procedure Qualification (PQR) test. The macro-etches appear to comply with the contract documents. The fillet welds were measured at 6.0mm for the Maximum size single-pass and 9.0mm for the Minimum size multi-pass fillet welds.

Summary of Conversations:

No relevant conversations took place on this date.

Observed welding, testing or results:

is in general conformance with the contract requirements.

is not in conformance with the contract requirements.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

WELDING WITNESS REPORT

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Inspected By: McClary,David

Quality Assurance Inspector

Reviewed By: Lowry,Patrick

QA Reviewer